

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004914**Date Inspected:** 08-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate B (Lift 2)	NA	NA	QAMT

Tower

Heavy Shop 1: ZPMC QC inspector, Mr. Wang Lu (Testino) requested Caltrans QA to perform Green Tag MT inspection. Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001563 (Green Tag), item #2 and #6. The subassembly is identified as SSD1-SA61E/G and SSD1-SA61F/G, Lift 2 skin plate E, longitudinal stiffener plate weld joining skin plate. The welds are identified as SSD1-SA61E/G-2, -3, -11, -12 and SSD1-SA61F/G-14 & -15. The welds appeared to be QC-MT inspected and accepted by ZPMC. Caltrans QA-MT coverage was approximately 10%. The cover pass welds were found to be in compliance with the project specification. However, item #1 on the notification of witness inspection document called out Green Tag inspection. Mr. Testino stated that item #1 (Skin Plate "B") will be ready for Caltrans QA green tag inspection tomorrow 12-09-2008. See Caltrans Magnetic Test Report (TL-6028) dated, December 08, 2008 for additional information.

2	Tower Skin Plate D (Lift 2)	NA	NA	QA-MT
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Tower

Heavy Shop 2:

ZPMC QC inspector, Mr. Wang Lu (Testino) requested Caltrans QA to perform Green Tag MT inspection. Caltrans

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## WELDING INSPECTION REPORT

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QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001582 (Green Tag), item #2 and #3. The subassembly is identified as ESD1-SA376E/E and ESD1-SA376D/E, Lift 2 skin plate D, longitudinal stiffener plate weld joining skin plate. The welds are identified as ESD1-SA376E/E-11, -12 and ESD1-SA376D/E-2, -3, -9 & -10. The welds appeared to be QC-MT inspected and accepted by ZPMC. Caltrans QA-MT coverage was approximately 10%. The cover pass welds were found to be in compliance with the project specification. See Caltrans Magnetic Test Report (TL-6028) dated, December 08, 2008 for additional information.

### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 137-6471-0411, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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